






Work Order ID 66676

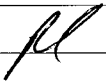




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Wednesday, February 23, 2011 3:26:20 PM


Item ID: D3200-1 Accept  Setup Start 
 Revision ID: Stop 
 Item Name: Door Post Block
 Start Date: 3/2/2011 Start Qty: 20.00  Cust Item ID:
 Required Date: 3/4/2011 Req'd Qty: 20.00  Customer:


Reference:


Approvals: Process Plan:  Date: 11-01-23 Tooling: Date: Run Start 
 QC: Date: SPC (Y/N): Date: Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3200	Rev A

100	BAND SAW	0.00							
									
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blank: 2.700" x 2.700		JL	11/03/22				(20)	

110	HAAS CNC VERTICAL MACHINING #1	0.00							
									
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	1-Machine D3200-1 as per Folio FA337 and Dwg D3200-2-Deburr		JL	11/03/23				(20)	

120	QC2- Inspect parts off machine FAI/FAIB	0.00							
									
QC	Memo	0.00							
Quality Control			JL	11/03/23					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID:	D3200-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Door Post Block					
Start Date:	3/2/2011	Start Qty:	20.00		Cust Item ID:	
Required Date:	3/4/2011	Req'd Qty:	20.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		11/3/28		20			
140 Packaging Packaging	Identify as per dwg & Stock Location: 40 Memo	0.00 0.00					11/3/30	20x	sf
150 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							11/3/31

MF
11-03-30

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Picklist Print

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Work Order ID: 66676

Parent Item: D3200-1

Parent Item Name: Door Post Block




Start Date: 3/2/2011

Required Date: 3/4/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A Removed from 9 Digit 06-01-25 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10 S 		Purchased	No			100	sf	368.1000	0.05	1.052632		SL 11/03/22	
UHMW 1" Black													

Location

Loc Qty

Loc Code

MAT

368.1

115955

38.8

116554

108.3

116796

18

116797

203

1.1

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	66674
Description: Door Post Block		Part Number:	D3200-1
Inspection Dwg: D3200	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.196	+0.005 -0.000	.196	✓		Vern. JL-3	
0.405 x 100°	+/-0.010	.410 x 100°	✓		"	
R0.100	+/-0.010	.100	✓			
R0.130	+/-0.010	.130	✓			
1.630	+/-0.005	1.630	✓		"	
0.440	+/-0.030	.435	✓		"	
2.500	+/-0.010	2.500	✓		"	
1.845	+/-0.010	1.836	✓		H-G	
0.015 - 0.050	N/A	.045	✓		"	
1.000	+/-0.010	1.000	✓		"	
1.620	+/-0.005	1.620	✓		"	
2.500	+/-0.030	2.495	✓		"	
0.750	+/-0.030	.750	✓		"	

Measured by: SL	Audited by: SA	Prototype Approval:	N/A
Date: 11/03/22	Date: 11/3/28	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.12	New Issue P/O D412-698-015	KJ/RF	77

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SHOP COPY

RETURN TO

ENGINEERING

UNCONTROLLED
SUBJECT TO

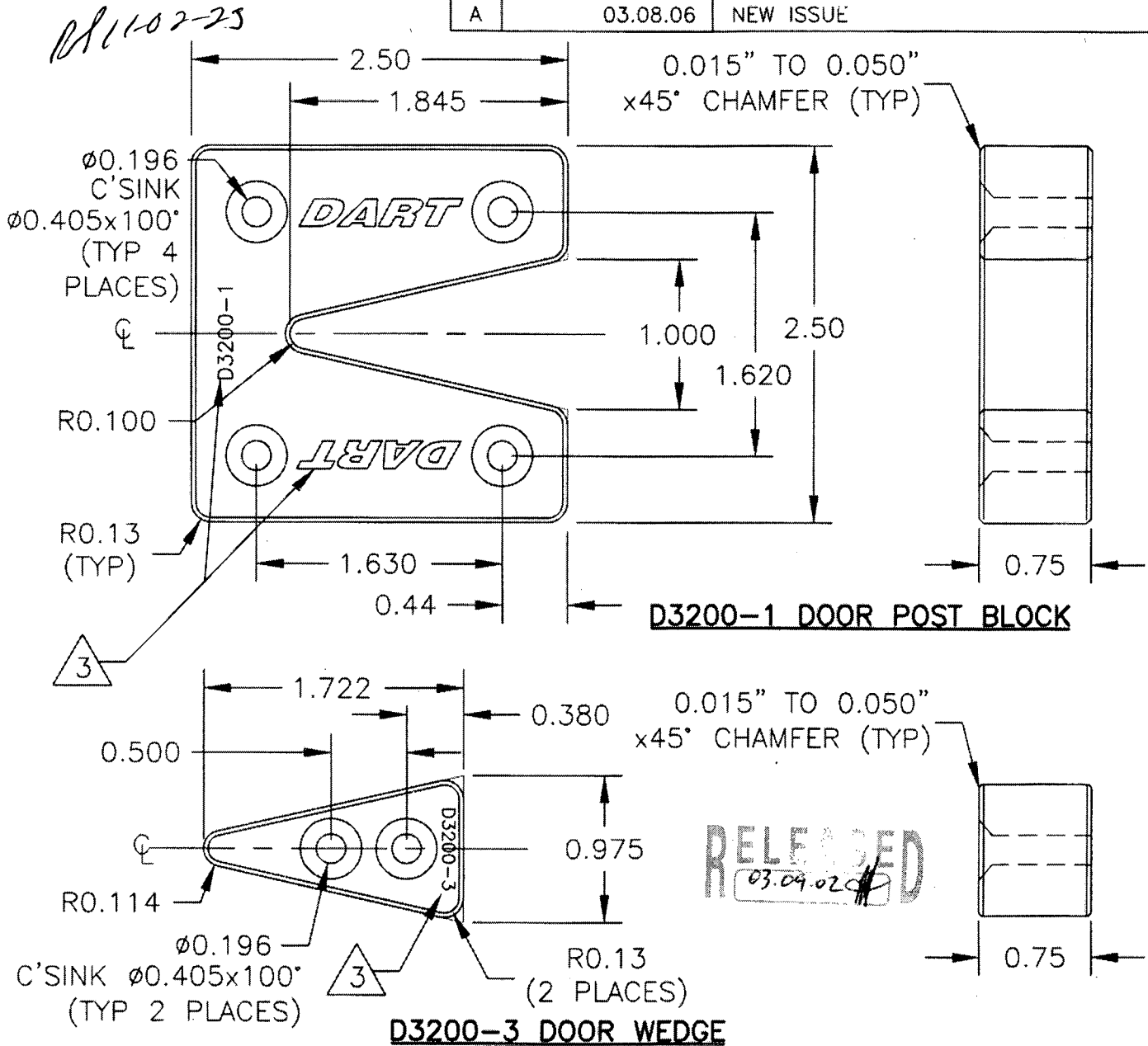


WITHOUT NOTICE
WORK ORDER

NO 06676



DESIGN UP	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3200	REV. A SHEET 1 OF 1
DATE 03.08.06	TITLE DOOR WEDGE		SCALE 1:1
A	03.08.06	NEW ISSUE	



D3200-1/-3

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
- 2) PARTS ARE SYMMETRIC ABOUT CENTERLINE
- 3) ENGRAVE DART LOGO AND P/N IN AREAS SHOWN
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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